

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000114**Date Inspected:** 25-Jan-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**Witness:**      **Procedure Qualification Record**  
                    **Welding**                      **NDT**

**Welder Qualification**                      **Fracture Critical**  
**Mechanical Testing, describe:** See below

**Index Lot #:** B31-021-07**Witness Lot #:** B31-023-07**Bridge No:** 34-0006**Component:** N/A**Welder:** Jiang Xiao Hu**ID #:** N/A**Joint Description:** Non Standard

N/A

**WPS ID #:** PWPS-B-T-3231-F(5)

N/A

**Base Metal:** ASTM A709      Gr HPS485W

N/A

**PQR ID #:** HP2006107-10

N/A

**Thickness:** 75mm

N/A

**Process:** FCAW-G

N/A

**Electrode Spec/Class:** A5.20/E71T1-1

N/A

**Positions:** 1G

N/A

**Backing Material:** ASTM A709      Gr HPS485W

N/A

**CWI:** Huang Wei

N/A

**Average Amps:**

N/A

**AWS Code:** D1.5-2002

N/A

**Average Volts:**

N/A

**Applicable Sec:** 5.13

N/A

**Travel Speed:**

N/A

**Heat Input:**

N/A

**Preheat:**

N/A

**Summary of Items Observed:**

On this date the QA representative Joe Lanz arrived at Zhenhua Port Machinery Company (ZPMC) of Shanghai, China to witness mechanical tests of Performance Qualification weld test plate ID HP2006107-10 in accordance with the contract documents. The QA inspector observed Charpy V-notch tests in accordance with AWS D1.5-2002 paragraph 5.18.5 and contract special provisions, an All Weld Metal Tensile test in accordance with AWS D1.5-2002 paragraph 5.18.4, 2 reduced section tensile coupon tests in accordance with AWS D1.5-2002 Section 5.18.1, 4 side bend tests in accordance with AWS D1.5-2002 paragraph 5.18.3 and 3 macroetch samples which had been etched in accordance with AWS D1.5-2002 paragraph 5.18.2. The above samples were found to be acceptable in accordance with AWS D1.5-2002 section 5.19. Caltrans Lot Number B31-023-03 was assigned for tracking purposes.

**Summary of Conversations:**

See TL-6034 Source Inspection Report for details.

**Observed welding,testing or results:**

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## WELDING WITNESS REPORT

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is in general conformance with the contract requirements.  
is not in conformance with the contract requirements.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Lanz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Wright,Mark	QA Reviewer

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